

Split
Work Order ID 158814-2

158814

Page 1

Friday, March 31, 2017 7:15:41 PM

Item ID: D5354-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: R66 Fwd Clamp Assembly, LH
 Start Date: 4/4/2017 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 4/6/2017 Req'd Qty: 3.00 *3* Customer:
 Reference: SCHEDULED
 Approvals: Process Plan: _____ Date: MAR 31 2017 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5354	C								
100	BAND SAW	0.00							DAC 08 9-99
100									
Bandsaw	Memo	0.02							
Jeaspa Bandsaw	Cut Blanks at 4.250"								
110	HAAS CNC VERTICAL MACHINING #1	1.26							DAS 08 9-99
110									
HAAS 5 AXIS	Memo	3.80							
HAAS CNC vertical machine #5	1-Machine per folio FB436 (D5354-1) DWG REV: C FOLIO REV: AA								
	2- deburr and break all sharp edge as per dwg								

Work Order ID 158814

158814

Friday, March 31, 2017 7:15:41 PM

Item ID: D5354-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 4/4/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 4/6/2017 Req'd Qty: 3.00

3

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.08							DAS 08 9-89
120									
QC	Memo	0.50							
Quality Control									
130	QC8- Inspect parts - second check	0.00							DAS 14 9-89
130									
QC	Memo	0.06							
Quality Control									
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	216.00							
Outsource process - Anodize	Issue P/O to ATG : 36041								
	Black Anodize as per Dwg D5354								
	Certification of Conformity is required.								

3 APR 19 2017 DAS
13
9-89

Work Order ID 158814***158814***

Friday, March 31, 2017 7:15:41 PM

Item ID: D5354-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 4/4/2017 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 4/6/2017 Req'd Qty: 3.00 ***3***

Customer:

Reference: SCHEDULED

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.06							
Packaging	Certification of Conformity is required.								
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.06							
Quality Control									

3x SP17-511

3

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MAY 11 2017

100

Work Order ID 158814

Friday, March 31, 2017 7:15:41 PM

158814

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Item ID: D5354-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 4/4/2017 Start Qty: 3.00 *3*

Cust Item ID:

Required Date: 4/6/2017 Req'd Qty: 3.00 *3*

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>5F576</u>	0.00				/	JUN 20 2017		DAS 6 9-89
180	Packaging	0.03							
	Memo								
	Packaging								
190	QC21- Final Inspection - Work Order Release	0.00							
190	QC	0.30							
	Quality Control								

17/6/2017

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JUN 20 2017

Picklist Print

Friday, March 31, 2017 7:15:40 PM

Page 1

Work Order ID: 158814

158814

Parent Item: D5354-041

D5354-041

Parent Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 4/4/2017

Required Date: 4/6/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 16.01.05 NEW ISSUE DD VERF:JLM IPP
REV:B 16.01.26 REV.A DWG DD VERF:JLM IPP REV:C
16/07/08 Per rev.B dwg. JFS Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.250X04.50
0

Purchased No

100

f

8.0764

0.354

1.117895

M6061T6B1 250X04 500

6061-T6 Bar 1.25 X 4.50

**

17-04-05

Location

Loc Qty

Loc Code

MAT004

8.0764

m133038

0.3014

→ m134776

7.775

1.075**

JUN 19 2017

D5316-1

Manufactured No

160

Each

9.0000

1

3

D5316-1

T-Bolt Strap

**

DAS
30
9-89

Location

Loc Qty

Loc Code

ST163

9

155235

9

1

D5351-1

Manufactured No

160

Each

0.0000

2

6

D5351-1

T-Bolt Spacer

**

DAS
30
9-89

JUN 19 2017

158932

2

8160624

4

Picklist Print

Friday, March 31, 2017 7:15:40 PM

Page 2

Work Order ID: 158814

158814

Parent Item: D5354-041

D5354-041

Parent Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 4/4/2017

Required Date: 4/6/2017

Start Qty: 3.00

Required Qty: 3.00

MS21043-3

Purchased

No

160

Each

936.0000

2

6

MS21043-3

Nut

**

DAS

30

9-89

JUN 19 2017

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

203

m130673

11

m136182

192

GA

215

m133990

27

m136182

188

ST302

369

m136986

369

ST304

69

m131340

69

M137459

NAS1149D0332J

Purchased

No

160

Each

1,682.000

2

6

NAS1149D0332.J

Washer

**

DAS

30

9-89

JUN 19 2017

Location

Loc Qty

Loc Code

FP

28

m136015

28

GA

522

m136643

522

ST260a

1000

m137075

1000

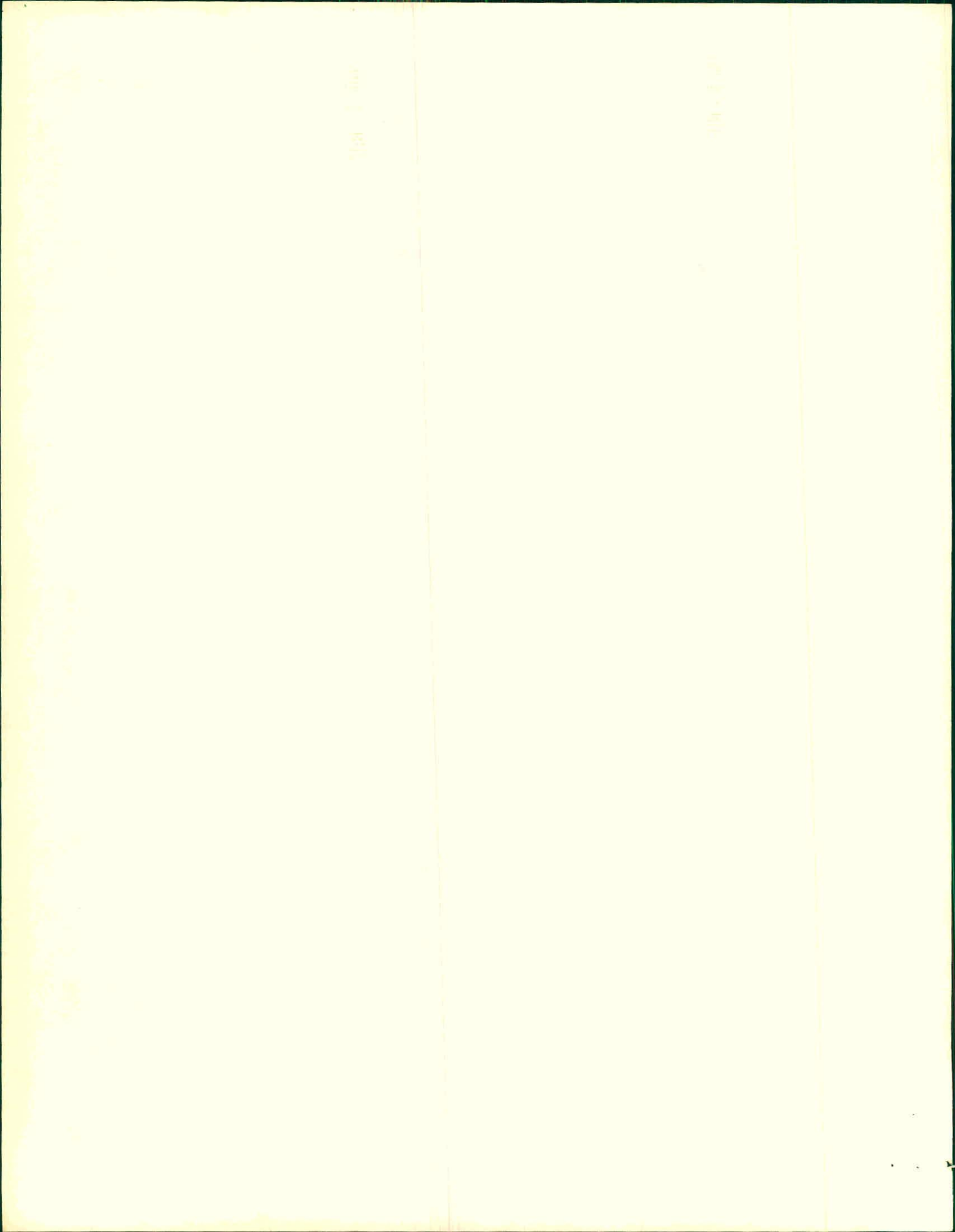
ST264

132

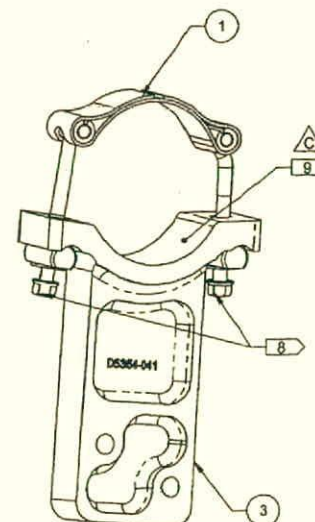
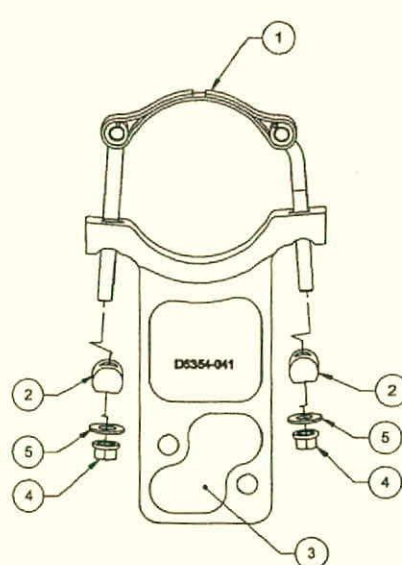
m136015

132

M137736



ITEM	QTY -041	P/N	DESCRIPTION
	X	D5354-041	R66 FWD CLAMP ASSY, LH
1	1	D5316-1	T-BOLT STRAP
2	2	D5351-1	T-BOLT SPACER
3	1	D5354-1	SUPPORT, LH
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	NAS1149D0332J	WASHER
6	A/R	PROSEAL 890	SEALANT



D5354-041 R66 FWD CLAMP ASSY, LH

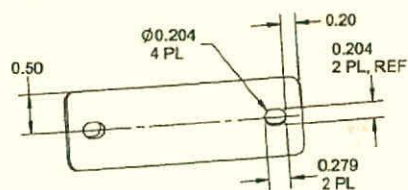
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: AS SHOWN ON D5354-1
- 7) WEIGHT: 0.37 lbs
- 8) SECURE NUTS WITH 1-2 THREAD AS SHOWN
- 9) APPLY AN EVEN LAYER OF PROSEAL 890 (0.02"-0.03" THICK) ON INSIDE SURFACE

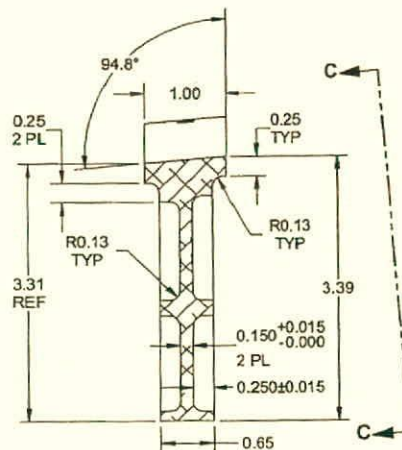
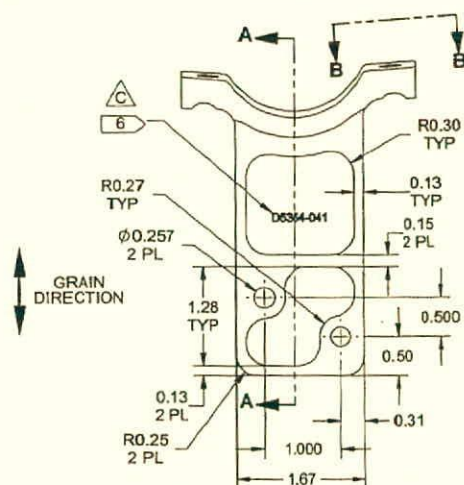
RELEASED
2017-03-22
P/N 17-535

C	ADDED ENGRAVING AND REVISE NOTE 8 AND LOCATION OF PROSEAL (ZN A8-1, C3-1, A8-2 C3-2, A8-3, C2-3, C7-3, A8-4, B2-4, C6-4)	RF	17.02.09
B	REDESIGN -1/-041, ADD -2/-042, REMOVE -043 (ZN A5-1, A5-2, A5-3, A5-4); ADD NOTE 9 (ZN A8-1, A8-2)	RF	16.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D5354	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 FWD CLAMP ASSEMBLY	NTS
DATE	17.02.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

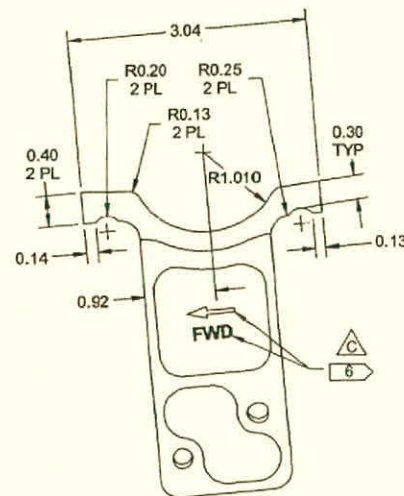
APPROVED



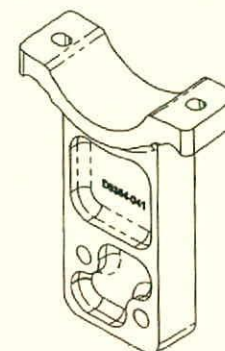
VIEW B-B
(TYPICAL)



SECTION A-A



VIEW C-C



D5354-1 SUPPORT, LH

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH ASSEMBLY P/N, FWD & ARROW PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.29 lbs
- 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5354-1 REV. C.SLDPR

RELEASED
2017-03-22

APPROVED

DESIGN	RF
DRAWN	RF
CHECKED	VS
MFG. APPR.	JFS
APPROVED	HS
DE APPR.	DS
DATE	17.02.09

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D5354
REV. C
SHEET 3 OF 4
SCALE
NTS

TITLE
R66 FWD CLAMP ASSEMBLY
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DART AEROSPACE LTD		Work Order: 158814
Description: SUPPORT, LH		Part Number: D5354-1
Inspection Dwg: D5354 Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.279	+/-0.010	0.276	✓		Vern	GA-13
0.20	+/-0.030	0.199	✓		"	"
φ0.204	+0.005/-0.001	φ0.204	✓		"	"
0.50	+/-0.030	0.497	✓		"	"
R0.27	+/-0.030	R0.266	✓		R-G	ref.
φ0.257	+0.006/-0.001	φ0.260	✓		Vern	GA-13
1.28	+/-0.030	1.275	✓		"	"
0.13	+/-0.030	0.124	✓		Mic	GA-03
R0.25	+/-0.030	R0.250	✓		R-G	ref.
1.000	+/-0.005	1.000	✓		H-G	31006
1.67	+/-0.030	1.669	✓		Vern	GA-13
0.31	+/-0.030	0.310	✓		"	"
0.50	+/-0.030	0.499	✓		"	"
0.500	+/-0.005	0.499	✓		H-G	31006
0.15	+/-0.030	0.150	✓		Vern	GA-13
0.13	+/-0.030	0.125	✓		Mic	GA-03
R0.30	+/-0.030	R0.297	✓		R-G	ref.
R0.13	+/-0.030	R0.125	✓		"	"
0.25	+/-0.030	0.238	✓		H-G	31006
94.8°	+/- 1/2°	94.8°	✓		Angle M.	CNC-17
1.00	+/-0.030	0.998	✓		Vern	GA-13
0.25	+/-0.030	0.254	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-G	ref.
3.39	+/-0.030	3.394	✓		H-G	31006
0.150	+0.015/-0.000	0.155	✓		Mic	118-120
0.250	+/-0.015	0.2475	✓		D-G	GA-08
0.14	+/-0.030	0.140	✓		Vern	GA-13
0.40	+/-0.030	0.396	✓		"	"
3.04	+/-0.030	3.041	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-G	ref.
R0.20	+/-0.030	R0.206	✓		"	"
R0.13	+/-0.030	R0.125	✓		"	"

Measured by: D.A.	Checked by: 14	QC Inspector:
Date: 17-04-08	Date: 17/04/11	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order ID PO36011

Purchase Order Date 4/19/2017

PO Print Date 4/25/2017

Page Number 3 of 5

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Chantal Lavoie

Line Total: \$98.75

7 159347 D2348 WEARPLATE 5/5/2017 20.00 \$0.95 \$19.00
REV. C

Yes

5/5/2017

BLACK ANODIZE AS PER MIL-A-8625F TYPE 1 OR IB/IC/II/IIB CLASS 2

Line Total: \$19.00

8 158932 D5351-1 T-BOLT REV. A 5/5/2017 20.00 \$0.90 \$18.00
REV. C

Yes

5/5/2017

BLACK ANODIZE AS PER MIL-A-8625F TYPE 1 OR IB/IC/II/IIB CLASS 2

Line Total: \$18.00

9 158814 D5354-041 R66 CLAMP 5/5/2017 3.00
REV. C

Yes

5/5/2017

BLACK ANODIZE AS PER MIL-A-8625F TYPE 1 OR IB/IC/II/IIB CLASS 2

DAS
\$2.50
38
9-88
\$7.50

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

4/25/2017

6017-5-11



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: Q13270

Date: 05-May-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Ph. 615-652-6671		Ship Via	
Terms		OUR TRUCK	
Quantity	Description		
ea	Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20958 PO: PO36011 Line: 4		
25 ea	Part: 646.3719 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20959 PO: PO36011 Line: 5		
25 ea	Part: 646.3718 Custom Washer Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20960 PO: PO36011 Line: 6		
20 ea	Part: D2348 Wearplate Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20961 PO: PO36011 Line: 7		
20 ea	Part: D5351-1 T-Bolt Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20962 PO: PO36011 Line: 8		
3 ea	Part: D5354-041 R66 Clamp Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20963 PO: PO36011 Line: 9		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements.			
Made in Canada.			
Page 2 of 3			

DAS
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9-89

SP17511



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913270

Date: 05-May-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	OUR TRUCK

Quantity

Description

Date:

05/05/2017

Certified Signature:

[Signature]

Receiver Signature:

[Signature]

A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.

Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.

Made in Canada.

